

**Work Order ID 52379**

Tuesday, September 22, 2009 11:48:49 AM

Page 2

Item ID: D3514-043

Accept

Setup Start

Revision ID: A

**Work Order ID 52379**

Tuesday, September 22, 2009 11:48:49 AM

Page 1

Item ID: D3514-043

Accept

Setup Start

Revision ID: A

Stop

Item Name: Top Mounted Gimbal Assembly

Start Date: 9/23/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3514

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3514

ES 10/02/01 (4)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2) 8/10/02/01

(x4)

120

0.00



Identify as per dwg &amp; Stock Location:

Packaging

Memo

0.00

Packaging

10-2-17 (40)

# Picklist Print

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Page 1

Work Order ID: 52379



Parent Item: D3514-043RevA



Parent Item Name: Top Mounted Gimbal Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-6A Purchased No

No

100

Each

137.0000

4.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

137

112082

7

112513

30

112720

100

AN960JD10L

Purchased

No

100

Each

6,445.000

8.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6445

101291

16

104885

153

105793

236

109632

1040

110985

5000

D3514-047RevA

Manufactured

No

100

Each

0.0000

4.0000



Top Mounted Housing Assembly

EP 10/02/01

M113149 (42)

EP 10/02/01

8

EP 09/12/14

B50308 (2x)  
B53021 (2x)

# Picklist Print

Page 2

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Work Order ID: 52379

Parent Item: D3514-043RevA

Parent Item Name: Top Mounted Gimbal Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3522-1RevA

Manufactured

No

100

Each

13.0000

4.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

35370

13

D3523-3RevB

Manufactured

No

100

Each

6.0000

4.0000



Leg

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

35752

6

D3524-1RevA

Manufactured

No

100

Each

0.0000

4.0000



Lower Plate

D3531-041RevA

Manufactured

No

100

Each

0.0000

4.0000



Bracket Assembly

B5206 9(2)  
352380 (2)

352381 (1K)

9/30/12/14

4  
9/30/12/14

B54573 (1K)

3  
9/30/12/14

9/30/12/14

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Shop Packet Print

Page 2

# Picklist Print

Page 3

Tuesday, September 22, 2009 11:48:48 AM

Work Order ID: 52379



Parent Item: D3514-043RevA



Parent Item Name: Top Mounted Gimbal Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3533-3RevB

Manufactured

No

100

Each

176.0000

8.0000



Set Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

176

34899

78

35024

98

MS24693-S29

Purchased

No

100

Each

208.0000

16.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

208

103915

208

*EP 09/22/14*

*EP 09/22/14*

*16*

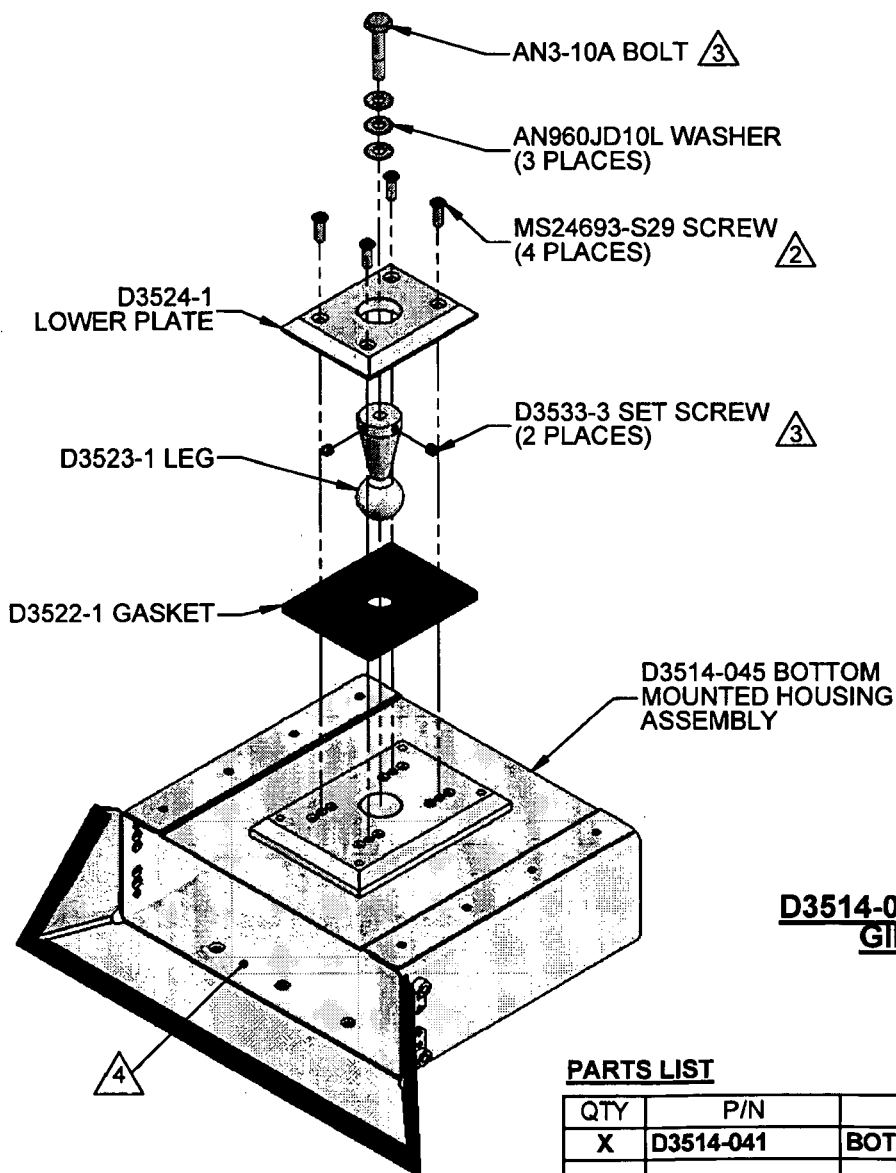
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Shop Packet Print

Page 3

**DART**

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CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3514</b>	REV. A SHEET 1 OF 9
DATE <b>07.06.18</b>		TITLE <b>GPS RECEIVER HOUSING</b>	SCALE 1:3
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE	

**RELEASED**  
07.08.03

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. **52379**

**D3514-041 BOTTOM MOUNTED  
GIMBAL ASSEMBLY****PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

**NOTE:**

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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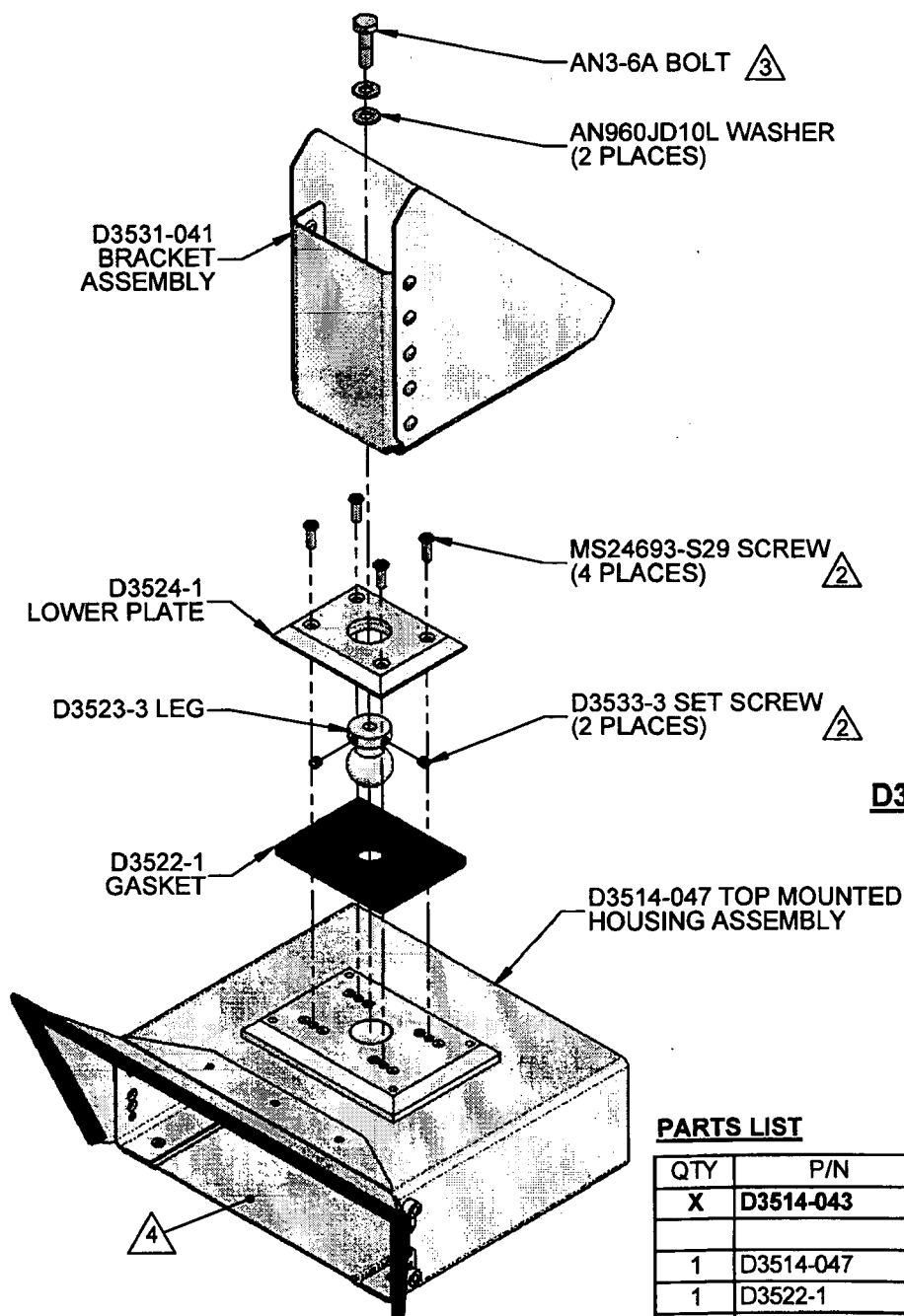
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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	SCALE 1:3

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07.08.03



**D3514-043 TOP MOUNTED  
GIMBAL ASSEMBLY**

**PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

**NOTE:**

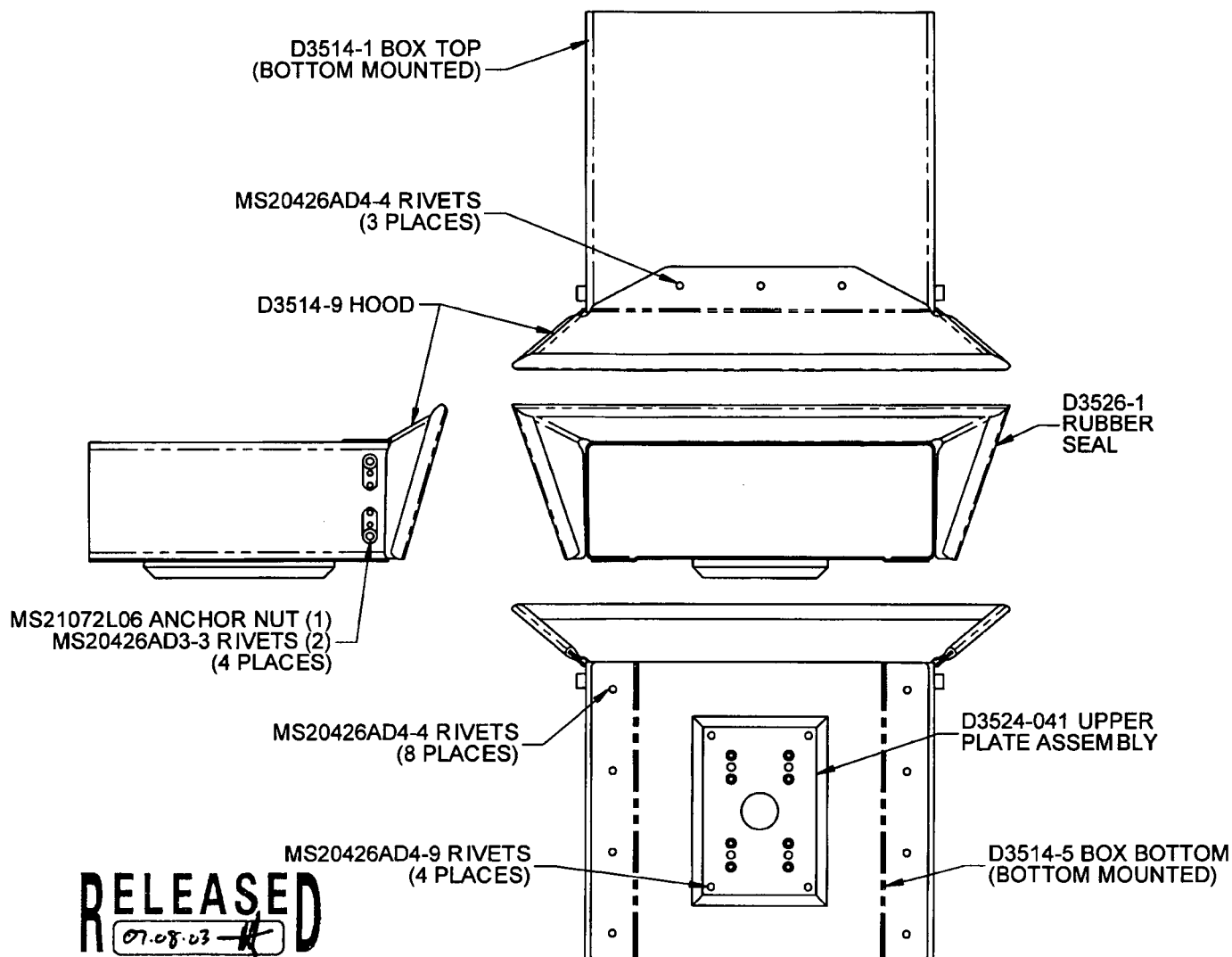
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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DATE <b>07.06.18</b>		TITLE <b>GPS RECEIVER HOUSING</b>	SCALE 1:3



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07.08.03 *[Signature]*

**D3514-045 BOTTOM MOUNTED  
HOUSING ASSEMBLY**

**NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

**PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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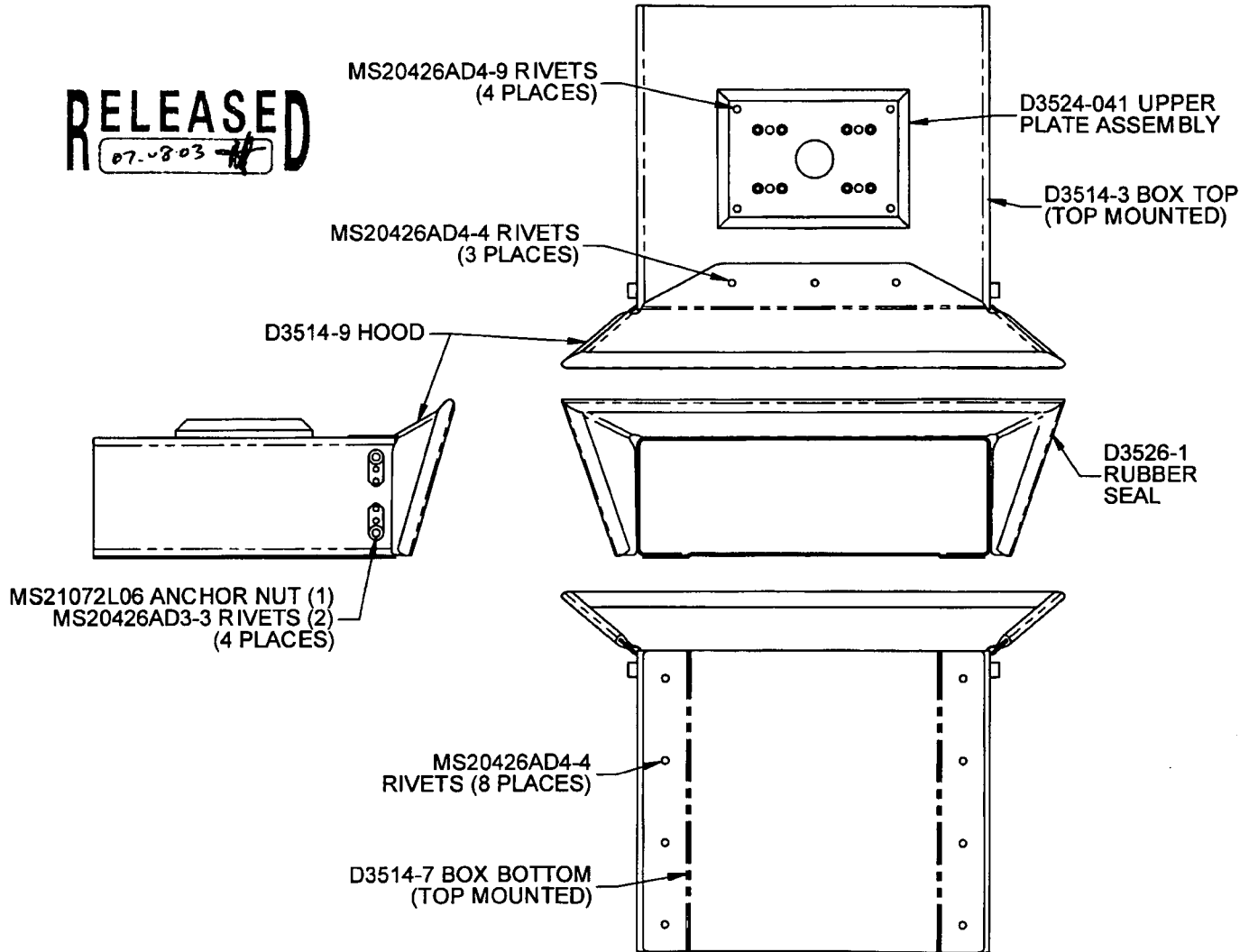
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07.08.03



**D3514-047 TOP MOUNTED  
HOUSING ASSEMBLY**

**NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

**PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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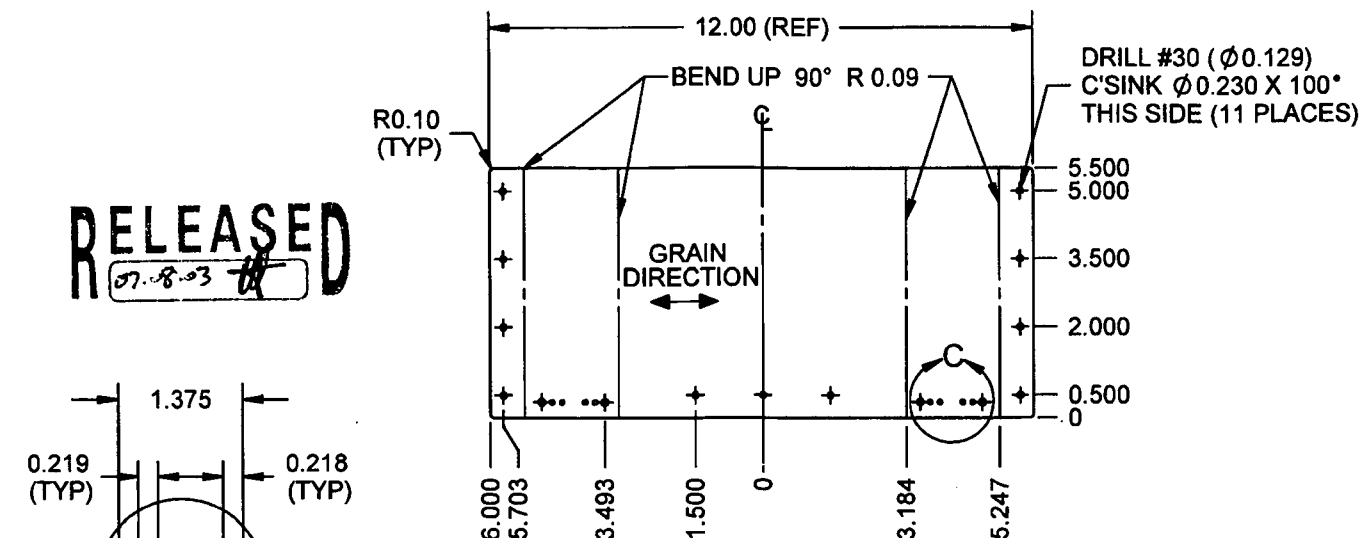
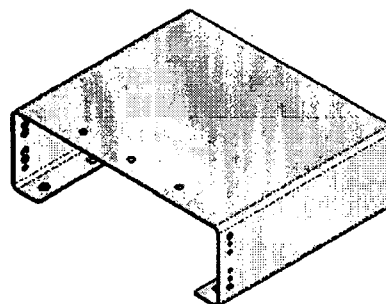
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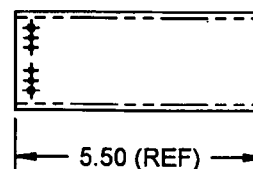
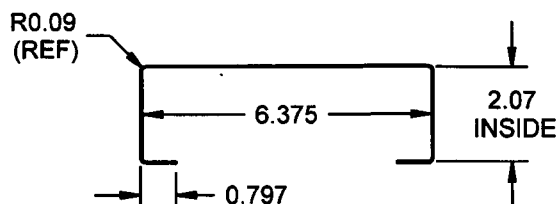
52329

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07.08.03**D3514-1F  
FLAT PATTERN**

DRILL #27 ( $\phi 0.144$ )  
(4 PLACES)

DRILL #40 ( $\phi 0.098$ )  
C'SINK  $\phi 0.182 \times 100^\circ$  THIS SIDE  
(8 PLACES) FOR RIVETS

**DETAIL C**  
SCALE 1:2

**D3514-1 BOX TOP (BOTTOM MOUNTED)****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

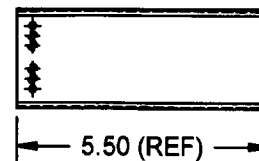
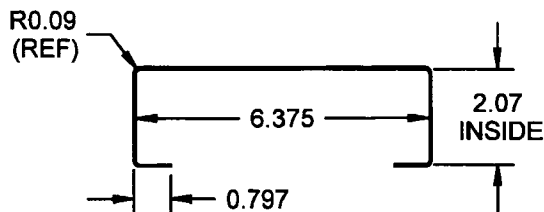
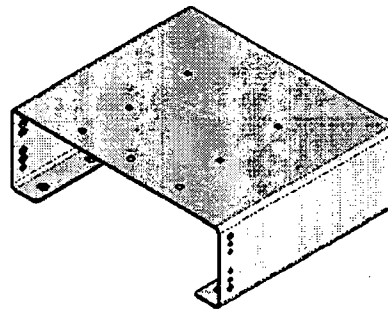
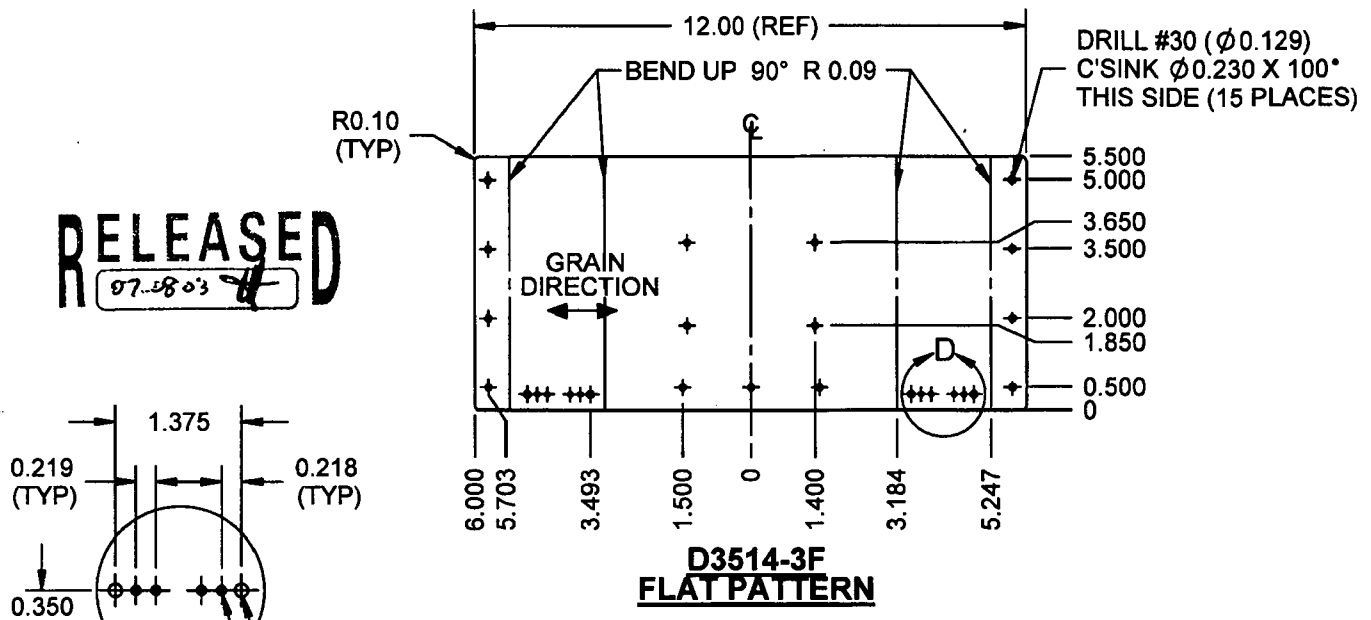
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DATE <b>07.06.18</b>		TITLE <b>GPS RECEIVER HOUSING</b>	SCALE 1:4

RELEASED  
97-2803



### D3514-3 BOX TOP (TOP MOUNTED)

#### NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

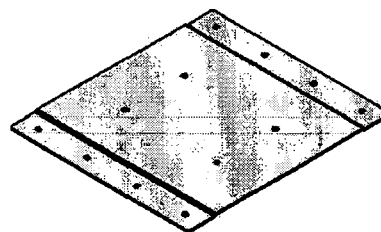
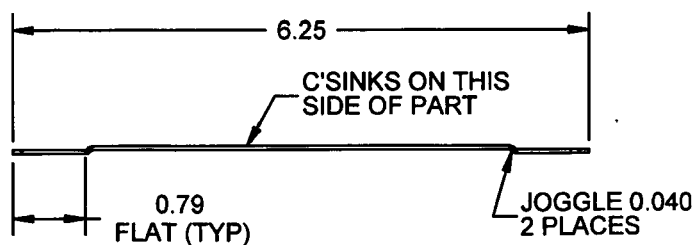
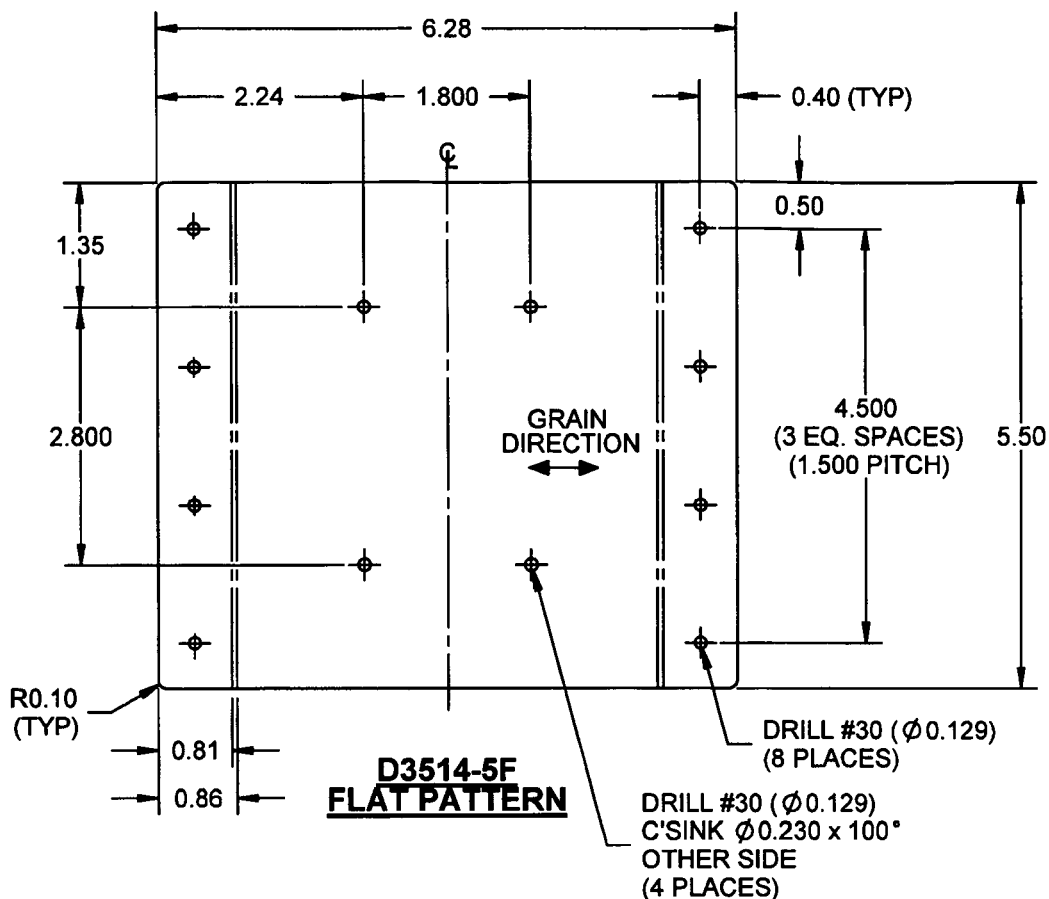
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**D3514-5 BOX BOTTOM (BOTTOM MOUNTED)****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINK ABOVE JOGGLE

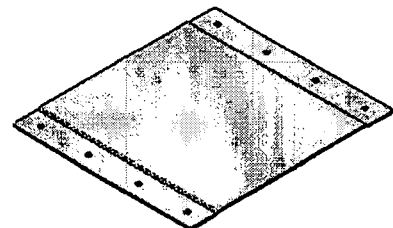
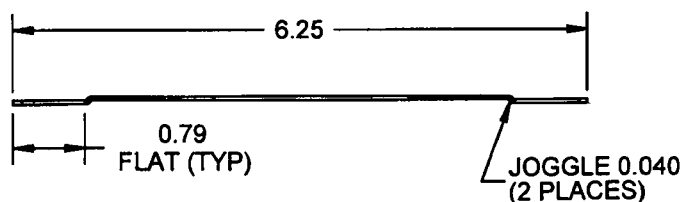
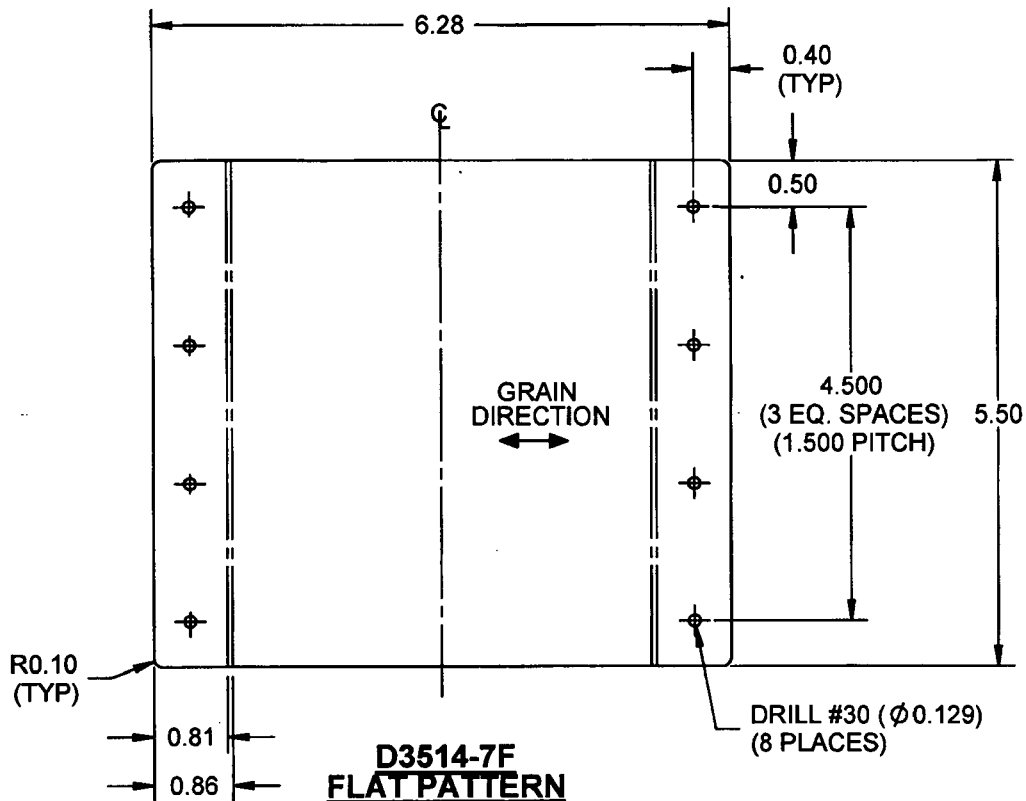
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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 8 OF 9 SCALE 1:2



### **D3514-7 BOX BOTTOM (TOP MOUNTED)**

#### **NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT Q

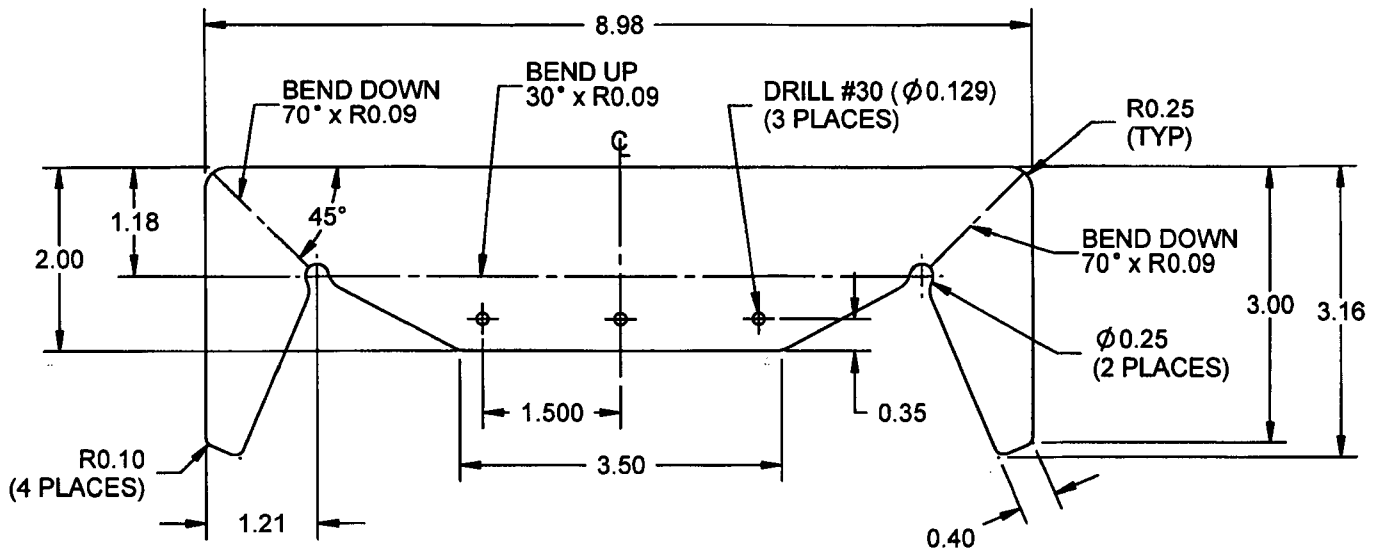
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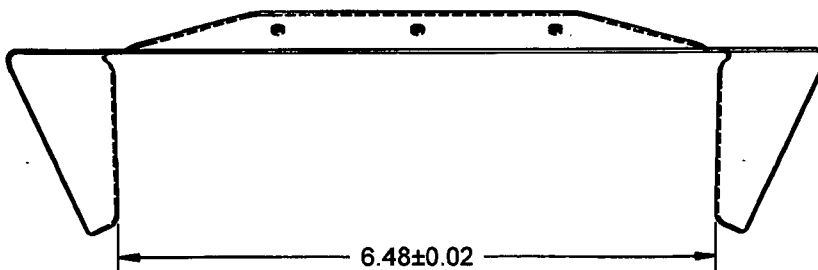


52379.

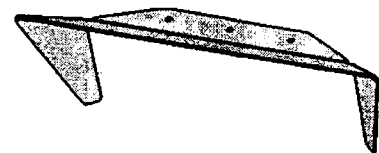
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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 9 OF 9 SCALE 1:2



**D3514-9F**  
**FLAT PATTERN**



**FRONT VIEW**



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07.08.03

**D3514-9 HOOD**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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